








**Work Order ID 66928**




Thursday, March 03, 2011 7:40:05 AM



Page 1

Item ID: D3319-1 Accept  Setup Start   
Revision ID: Stop   
Item Name: Wearplate  
Start Date: 3/3/2011 Start Qty: 8.00  Cust Item ID:  
Required Date: 3/11/2011 Req'd Qty: 8.00  Customer:  
Reference:

Approvals: Process Plan: H Date: 11-03-3 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3319	Rev B								
100		0.00							
 Waterjet	FLOW WATER JET								
	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3319 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary								(9)
110		0.00							
 QC	QC2- Inspect parts off machine FAI/FAIB								
	Memo	0.00							
Quality Control									
120		0.00							
 QC	QC8- Inspect parts - second check								
	Memo	0.00							
Quality Control									

1B11-3-3

1B11-3-3

11 03 03 (9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

# Work Order ID 66928

Thursday, March 03, 2011 7:40:05 AM



Page 3

Item ID: D3319-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 3/3/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170  QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00 0.00		8/11/03/14					
180  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00		8/11/03/14		(29)			
190  Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3  M 115128 Memo START TIME: 3:15 OVEN TEMPERATURE: 320° FINISH TIME: 3:45	0.00 0.00				9		BR 11-3-15.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 66928

Thursday, March 03, 2011 7:40:05 AM



Page 4

Item ID: D3319-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 3/3/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00				9	0	11/03/16	
Quality Control									
210	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3319-1, B/N: BXXXXX For Product Eligibility see PDA05-18 and Stock Location: <u>Y97</u>								
220	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/3/16

11/3/16

mk

11-03-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries



# Picklist Print

Thursday, March 03, 2011 7:40:11 AM

Page 1

Work Order ID: 66928

Parent Item: D3319-1

Parent Item Name: Wearplate




Start Date: 3/3/2011

Required Date: 3/11/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: B 05.10.14 Added step 9, dwg rev B KJ/EC  
IPP Rev:C Now on Waterjet 06-10-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S18GA  1010/1025 SHEET .048		Purchased	No			100	sf	124.0000	0.628	5.288421			
												6, 1811-3-3	

Location

Loc Qty

Loc Code

MAT

124

110996

4

116268

120

116268

9

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	66928
<b>Description: Wearplate</b>		<b>Part Number:</b>	D3319-1
<b>Inspection Dwg: D3319 Rev: B</b>		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.984	+/-0.010	4.979	✓		V IB02	
1.600	+/-0.010	1.603	✓		V	
2.660	+/-0.010	2.666	✓		V	
3.190	+/-0.010	3.196	✓		V	
3.563	+/-0.010	3.564	✓		V	
4.712	+/-0.010	4.710	✓		V	
0.60	+/-0.030	0.601	✓		V	
10.576	+/-0.010	10.576	✓		T H301	
11.942	+/-0.010	11.942	✓		T	
18.09	+/-0.030	18.09	✓		T	
Ø0.316 x 0.546	+0.006/-0.001 x +/-0.010	0.319 x 0.550	✓		V	
Ø0.316 x 0.670	+0.006/-0.001 x +/-0.010	0.319 x 0.676	✓		V	
Ø0.190	+0.005/-0.001	0.194	✓		V	

<b>Measured by:</b>	IB	<b>Audited by:</b>	[Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	11-3-3	<b>Date:</b>	11-03-03	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM [Signature]	[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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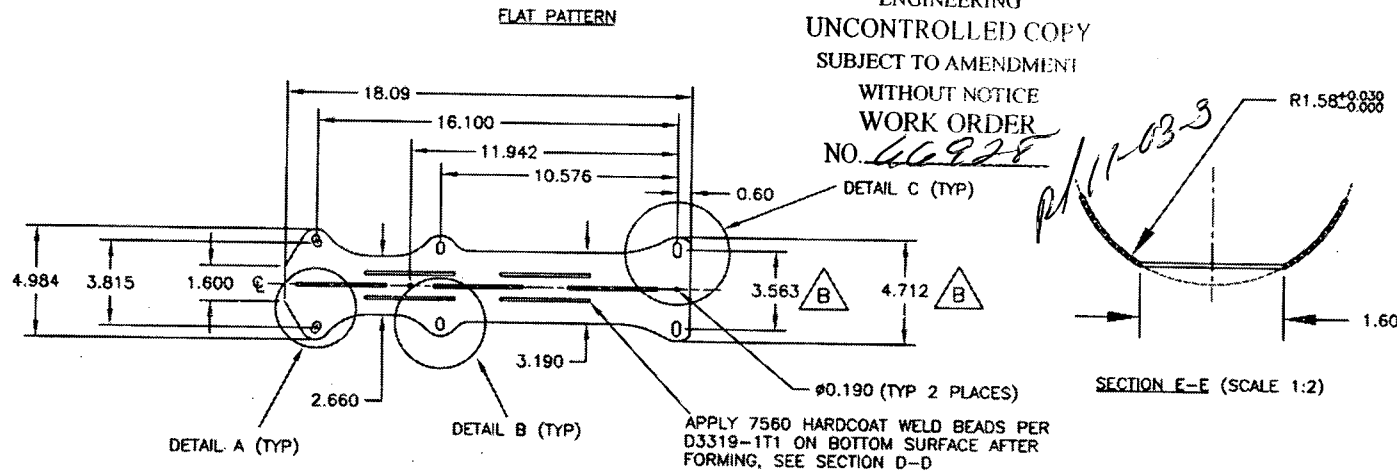
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RETURN TO

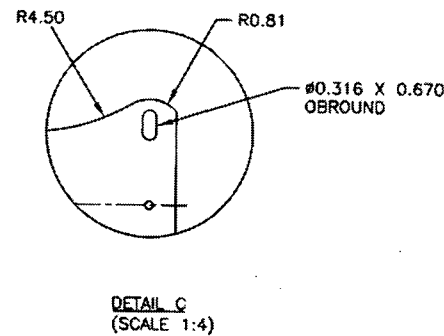
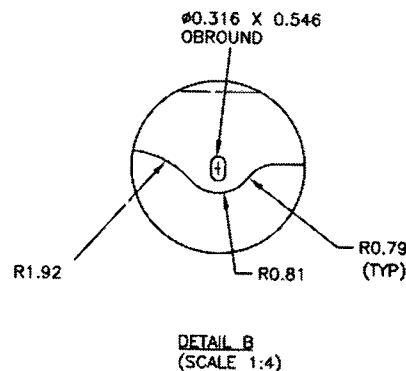
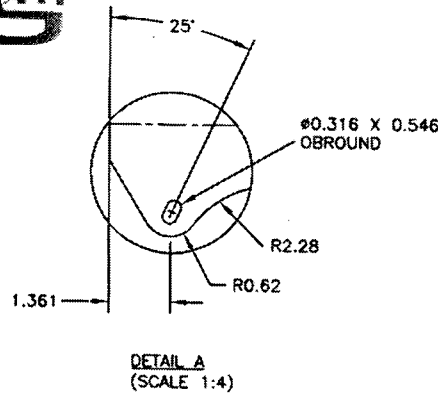
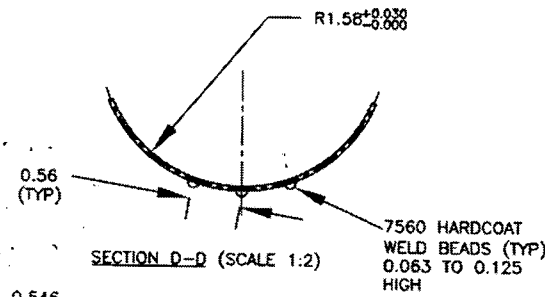
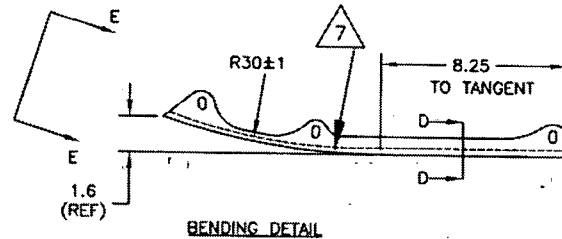
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER

NO. 66928



RELEASED  
05-09-30



D3319-1 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
P1	P1	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3319
DATE	TITLE	SHEET 1 OF 5
05.06.06	WEARPLATE	SCALE 1:8
A	04.09.24	NEW ISSUE
B	05.06.06	WIDEN HOLES, REDUCE WIDTH -3/-5/-7

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

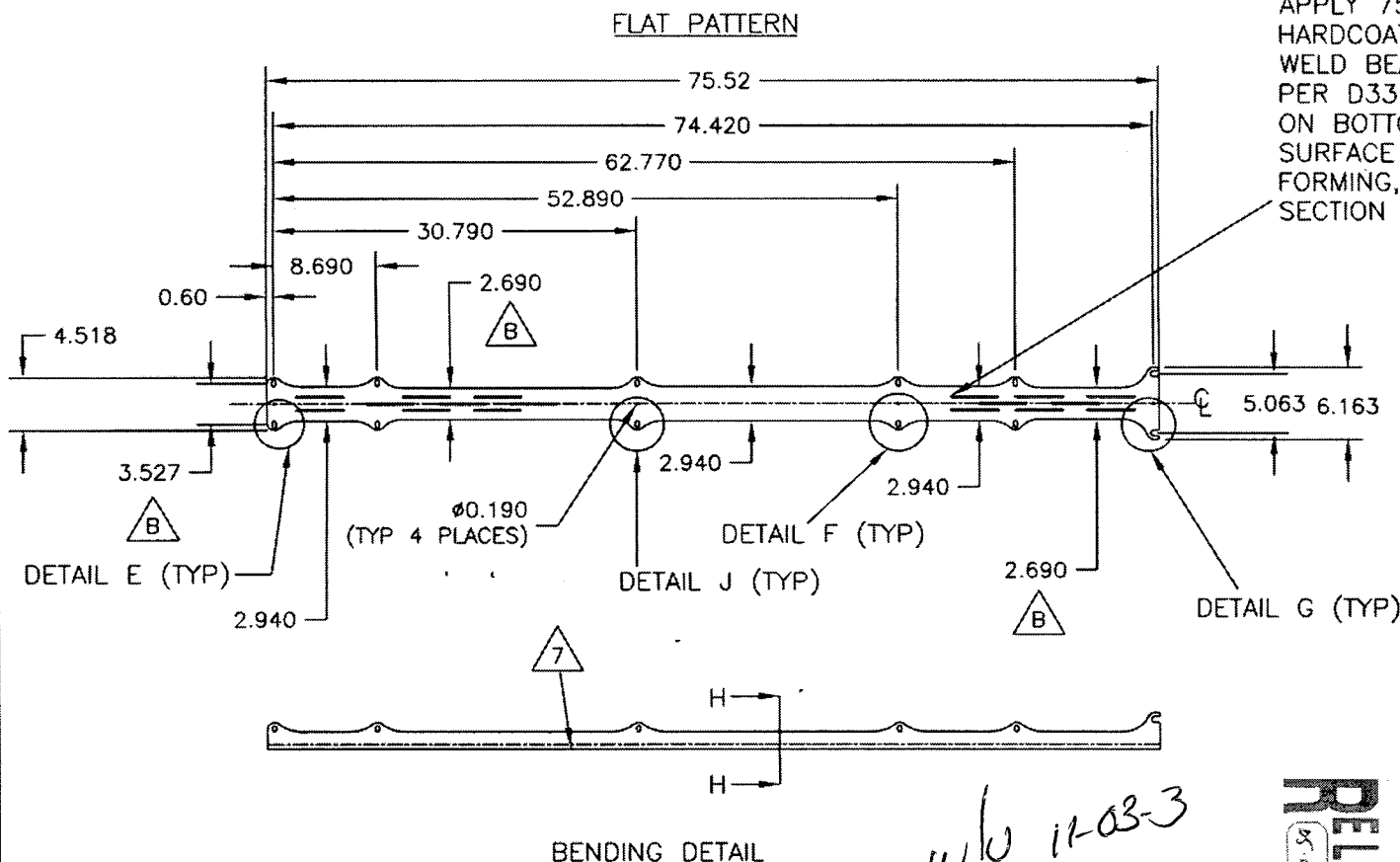
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN	OK	DRAWN BY	OK	DART AEROSPACE LTD
CHECKED	OK	APPROVED	OK	HAWKESBURY, ONTARIO, CANADA
DATE	05.06.06	TITLE	D3319	REV. B
		WEARPLATE		SHEET 2 OF 5
				SCALE 1:15

APPLY 7560  
HARDCOAT  
WELD BEADS  
PER D3319-3T1  
ON BOTTOM  
SURFACE AFTER  
FORMING, SEE  
SECTION H-H



**RELEASED**  
05-07-30

BENDING DETAIL

D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

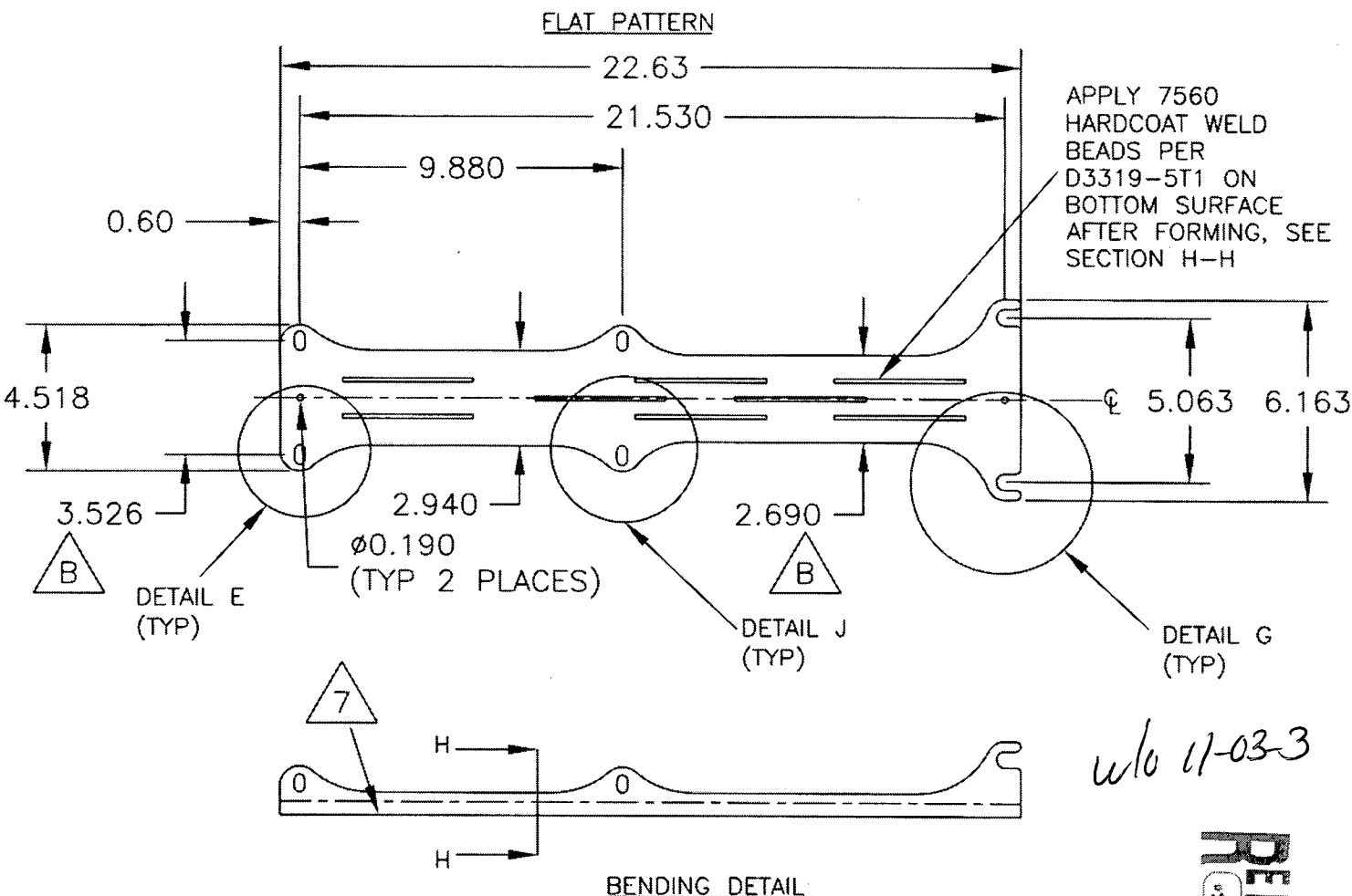
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DART**

DESIGN	D41	DRAWN BY	D41	DART AEROSPACE LTD
CHECKED	#	APPROVED	#	HAWKESBURY, ONTARIO, CANADA
DATE	05.06.06	TITLE	D3319	REV. B
		WEARPLATE		SHEET 3 OF 5
				SCALE 1:5



D3319-5 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

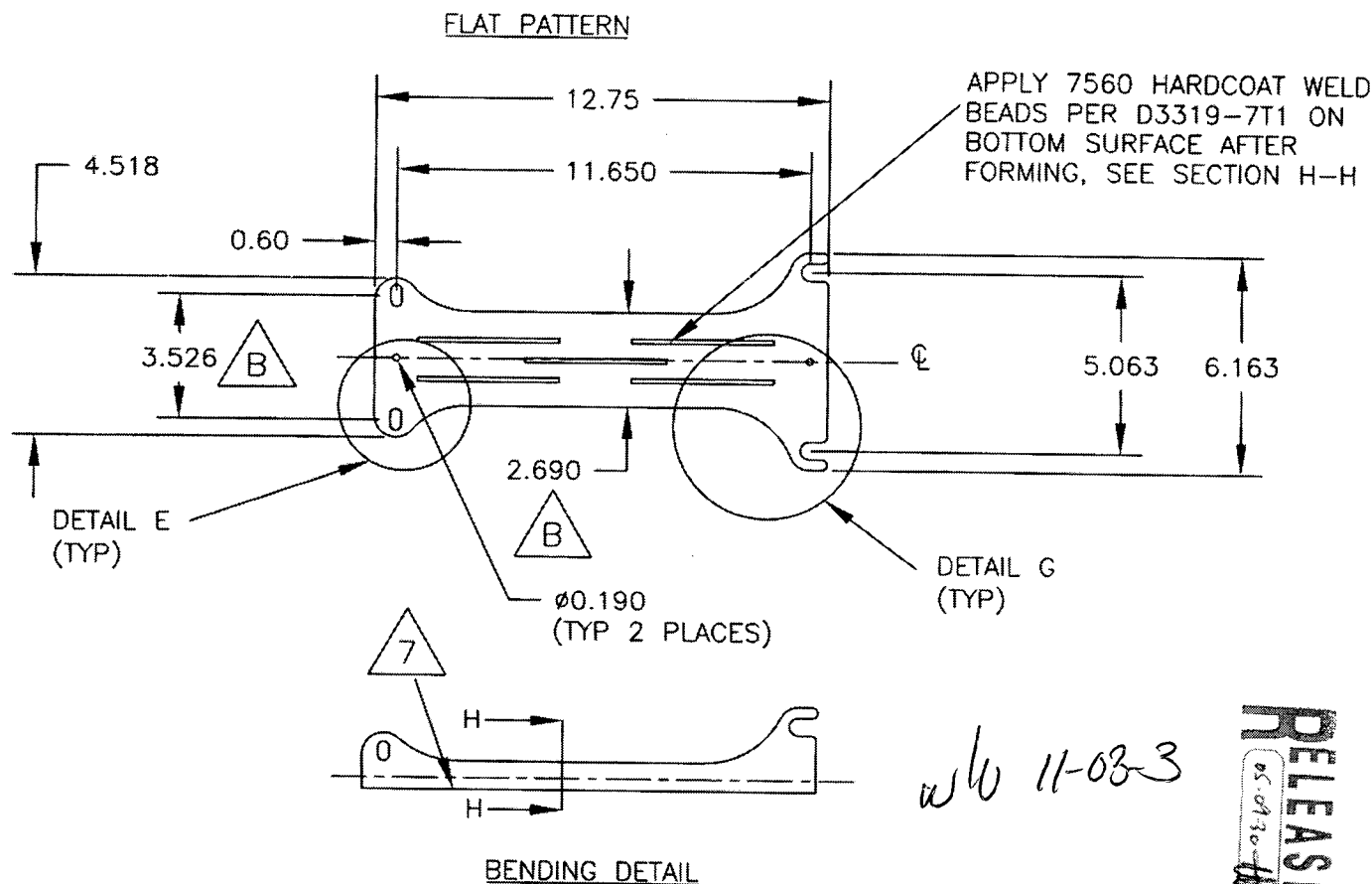
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**DART**

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CHECKED	PH	APPROVED	PH	DRAWING NO. D3319
DATE	05.06.06	TITLE	WEARPLATE	REV. B
		SCALE	1:5	SHEET 4 OF 5



D3319-7 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
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- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

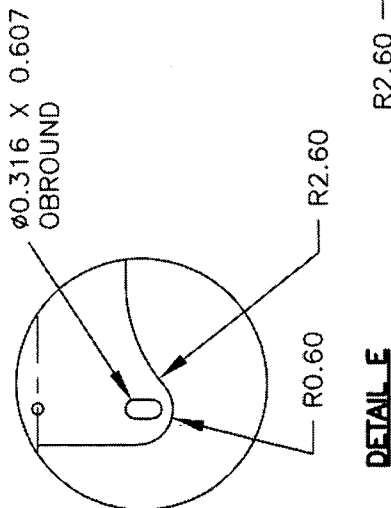
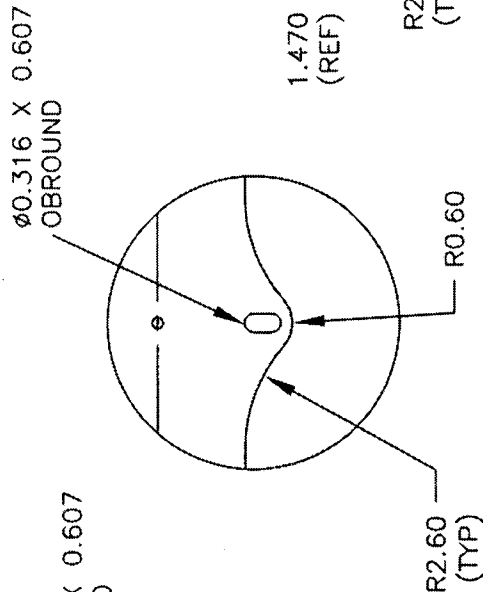
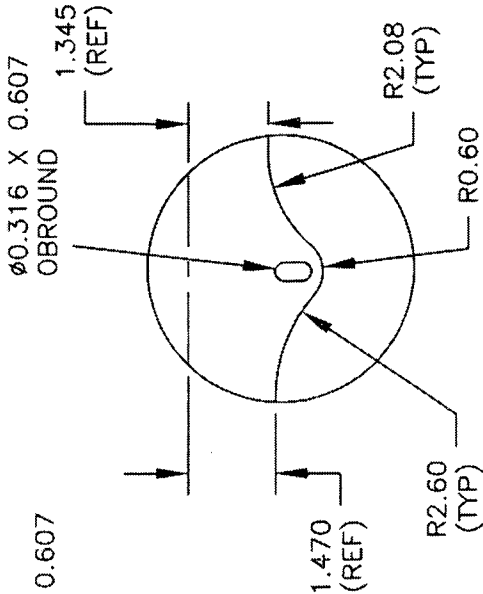
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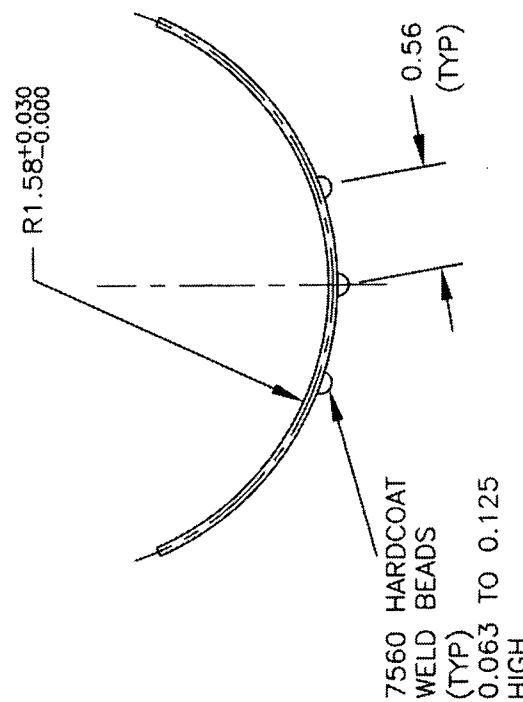
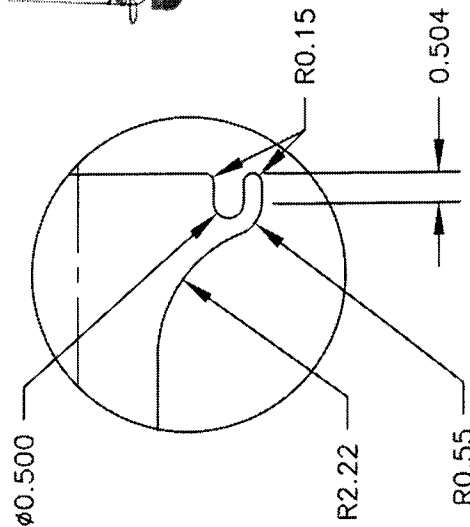


DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3319	REV. B SHEET 5 OF 5
DATE 05.06.06		TITLE WEARPLATE	SCALE 1:3



RELEASED  
05.09.30

*w/o 11-03-3*



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